

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016168**Date Inspected:** 13-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

BAY # 16

**ULTRASONIC TESTING**

ZPMC NWIT: 06396

This QA Inspector performed Ultrasonic Testing of approximately 10% of the length previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated an (UT) report on this date. The members are identified as the longitudinal diaphragm. The weld designations are as follows:

LD3031-001-007, 008, 019, 020

LD3033-001-016, 017

LD3034-001-007, 008, 032, 033

**TRIAL ASSEMBLY YARD**

This QA Inspector randomly observed the following work in progress.

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## WELDING INSPECTION REPORT

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### OBG LIFT 9 WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 047864 performing Shielded Metal Arc Welding process for weld 001 located on PCMK SEG051C. ZPMC QC Mr. Shun Gang Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-Fcm-Repair-1. Weld repair report identified as B-WR14553.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040609 performing Flux Cored Arc Welding process for weld 07 located on PCMK SEG057B. ZPMC QC Mr. Shi Lei was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 047864 performing Shielded Metal Arc Welding process for weld 001 located on PCMK CA061. ZPMC QC Mr. Shi Lei was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR1777.

This Quality Assurance (QA) Inspector observed ABF personnel performing ultrasonic testing on the bottom panel splice weld between OBG segment 9BW and 9CW. The weld number identified as OBW9B-008.

### OBG SEGMENT 10AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 202384 performing Flux Cored Arc Welding process for weld 008 located on PCMK SEG059B. ZPMC QC Mr. Zhou Peng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials

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## WELDING INSPECTION REPORT

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for your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer